

Work Order ID 64764

Thursday, December 16, 2010 11:44:00 AM

Page 1

Item ID: D2150

Accept

Setup Start

Revision ID:

Stop

Item Name: Packer Doubler, Hinge

Start Date: 12/16/2010 Start Qty: 30.00

Cust Item ID:

Required Date: 12/21/2010 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-2-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2150

Rev A

100

0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2150
Deburr if necessary

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

B10-12-16

BU

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B10-12-16

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

12/12/10

count
35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64764

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Page 2

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Setup Start



Revision ID:

Item Name: Packer Doubler, Hinge

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Start Date: 12/16/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 12/21/2010 Req'd Qty: 30.00



Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
Deburr

u/45

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

⇒ 10/12/20

35

8

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

Memo

0.00

0.00

MN5951

START TIME:

1:30

OVEN TEMPERATURE:

320°

FINISH TIME:

2:00

35 10-12-20

W/O:		WORK ORDER CHANGES					
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Work Order ID 64764

Thursday, December 16, 2010 11:44:00 AM

Page 3

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Revision ID:

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Start Date: 12/16/2010 Start Qty: 30.00

Required Date: 12/21/2010 Req'd Qty: 30.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= 744 10/12/20

35

9

170

Identify as per dwg & Stock Location: 007

0.00



Packaging

Memo

0.00

Packaging

10/12/21 35

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/21 MF 10-12-21

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Picklist Print

Thursday, December 16, 2010 11:44:04 AM

Page 1

Work Order ID: 64764

Parent Item: D2150

Parent Item Name: Packer Doubler, Hinge




Start Date: 12/16/2010

Required Date: 12/21/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP ☐ C ☐ 00.11.27 ☐ Re-format (mpp 2101) ☐ EC ☐
IPP Rev:D 06-08-23 Now on Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040  2024-T3 .040 sheet		Purchased	No			100	sf	220.9400	0.025	0.789474			



B10-12-16

Location

Loc Qty

Loc Code

MAT

31.2

114415

31.2

MAT22

189.74

110305

21.93

111786

9.66

112291

28.25

112331

52

113162

77.9

114415

36

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	64764
Description: Packer		Part Number:	D2150
Inspection Dwg: D2150 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010	.740	X		✓ HB02	
2.050	+/-0.010	2.047	X		✓	
0.231	+/-0.010	.231	X		✓	
1.217	+/-0.010	1.215	X		✓	
1.559	+/-0.010	1.564	X		✓	
2.300	+/-0.010	2.304	X		✓	
1.560	+/-0.010	1.560	X		✓	
0.250	+/-0.010	.251	X		✓	
1.328	+/-0.010	1.329	X		✓	
0.342	+/-0.010	.340	X		✓	
Ø0.098	+0.005/-0.000	.100	X		✓	
Ø0.171	+0.005/-0.000	.173	X		✓	
0.040	+/-0.010	.041	X		✓	

Measured by: B	Audited by: C	Prototype Approval:	N/A
Date: 10-12-16	Date: 10/12/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.28	New Issue	KJ/JLM	

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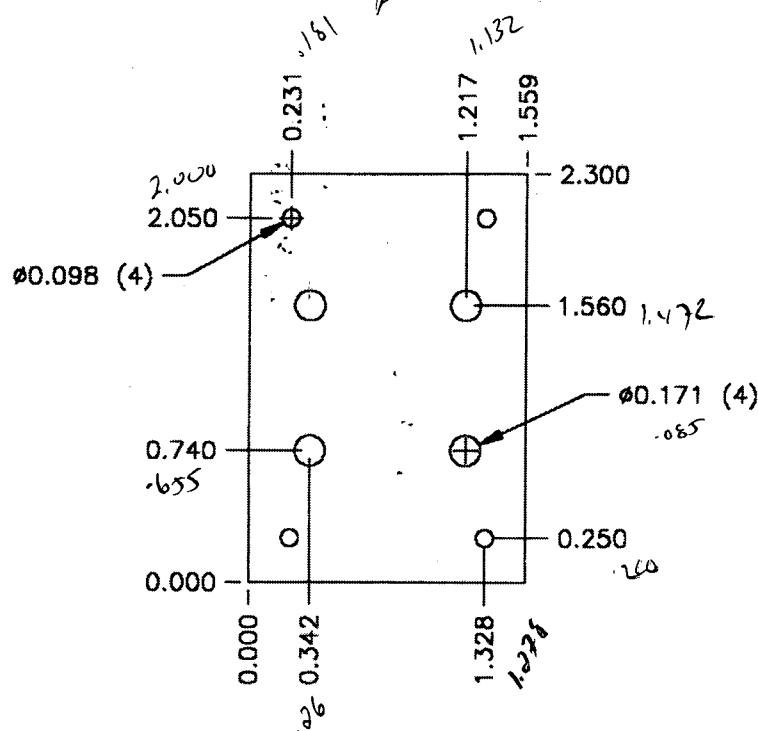


DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2150	REV. A SHEET 1 OF 1
DATE 95:05:01	TITLE PACKER		SCALE 1:1

RELEASED
96/02/13 BS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *64744*

BT 10-12-16



MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

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